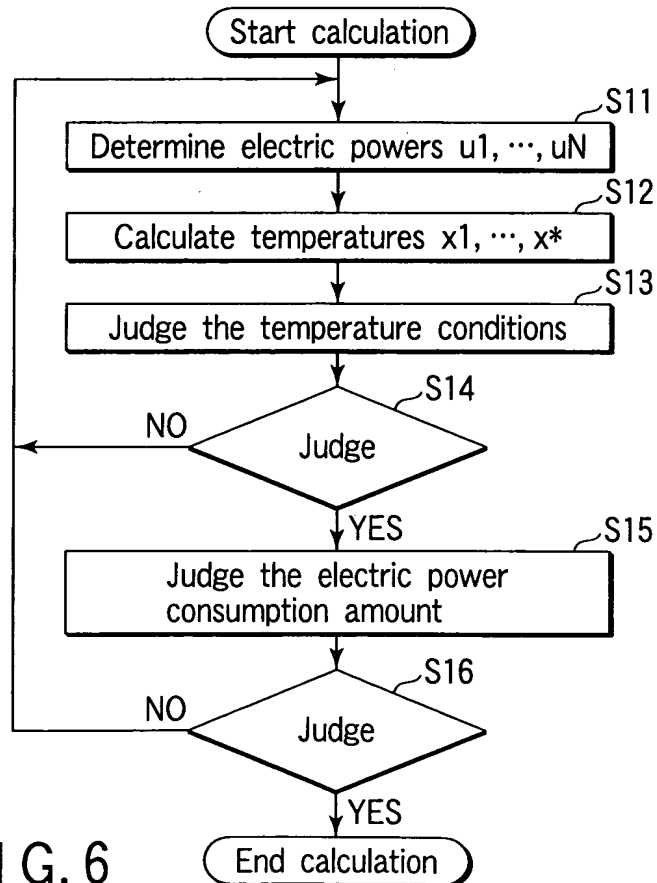
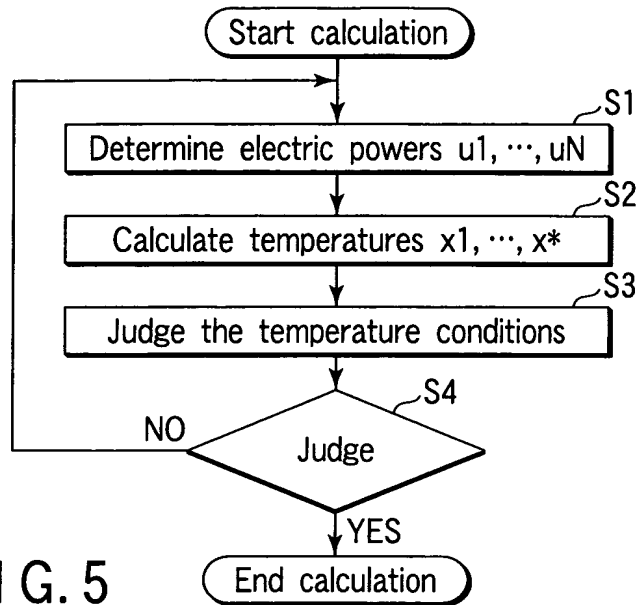


FIG. 4



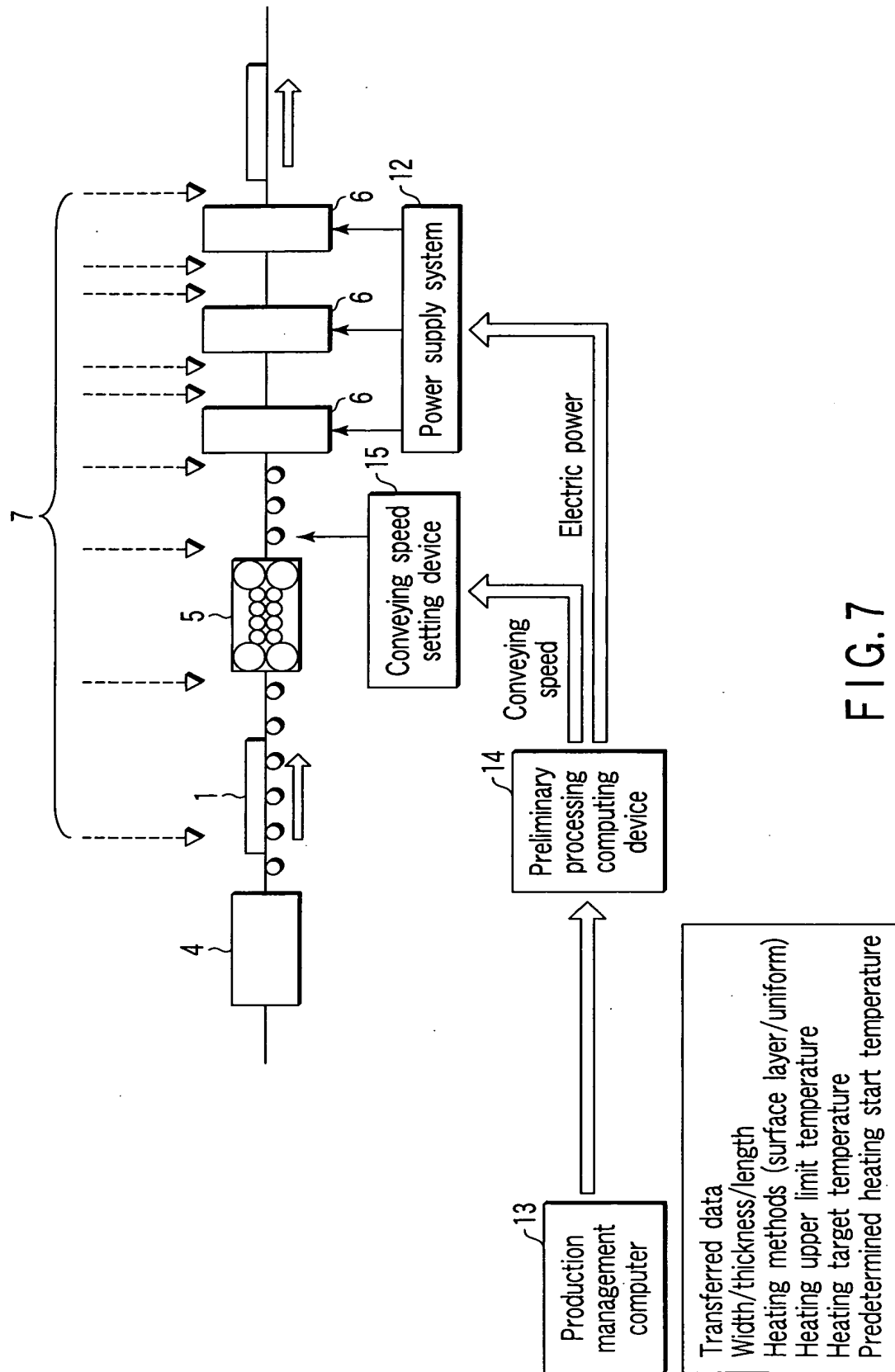


FIG. 7

Thickness (mm)	Width (mm)	1000				2000				3000			
		The number of passes	Speed 1	Speed 2	Speed 3	The number of passes	Speed 1	Speed 2	Speed 3	The number of passes	Speed 1	Speed 2	Speed 3
20	15	1	120	—	—	1	120	—	—	1	100	—	—
	25	1	120	—	—	1	120	—	—	1	90	—	—
	35	1	110	—	—	1	110	—	—	1	80	—	—
30	15	1	70	—	—	3	80	100	120	3	60	80	100
	25	1	60	—	—	3	60	80	100	3	50	70	80
	35	1	50	—	—	3	50	60	70	3	40	60	60
40	15	3	60	80	100	3	50	60	80	3	30	40	60
	25	3	50	70	80	3	40	50	60	3	20	30	40
	35	3	40	50	60	3	30	40	50	3	20	30	30

Unit of speed (m/minute)

FIG.8

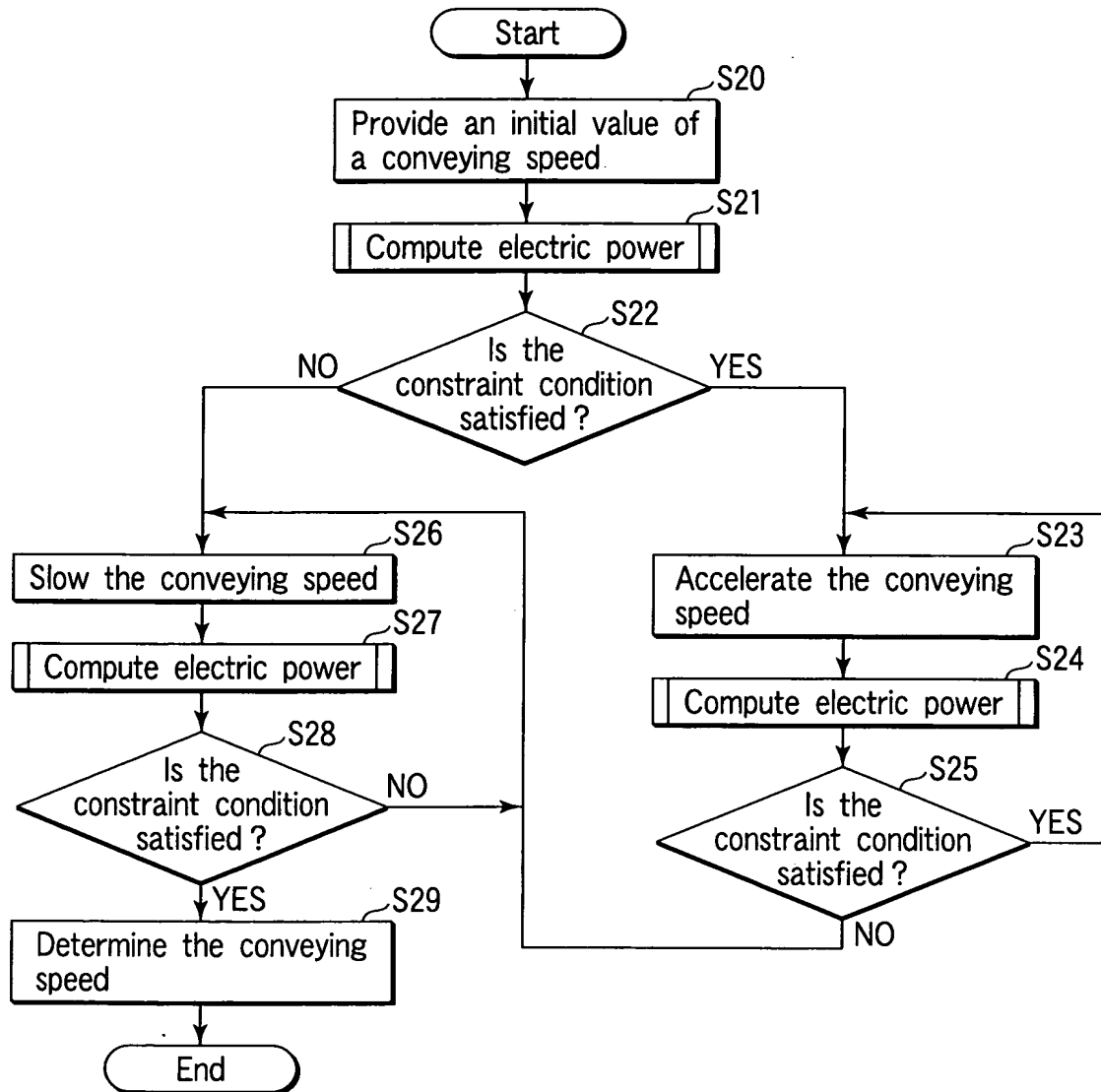


FIG. 9

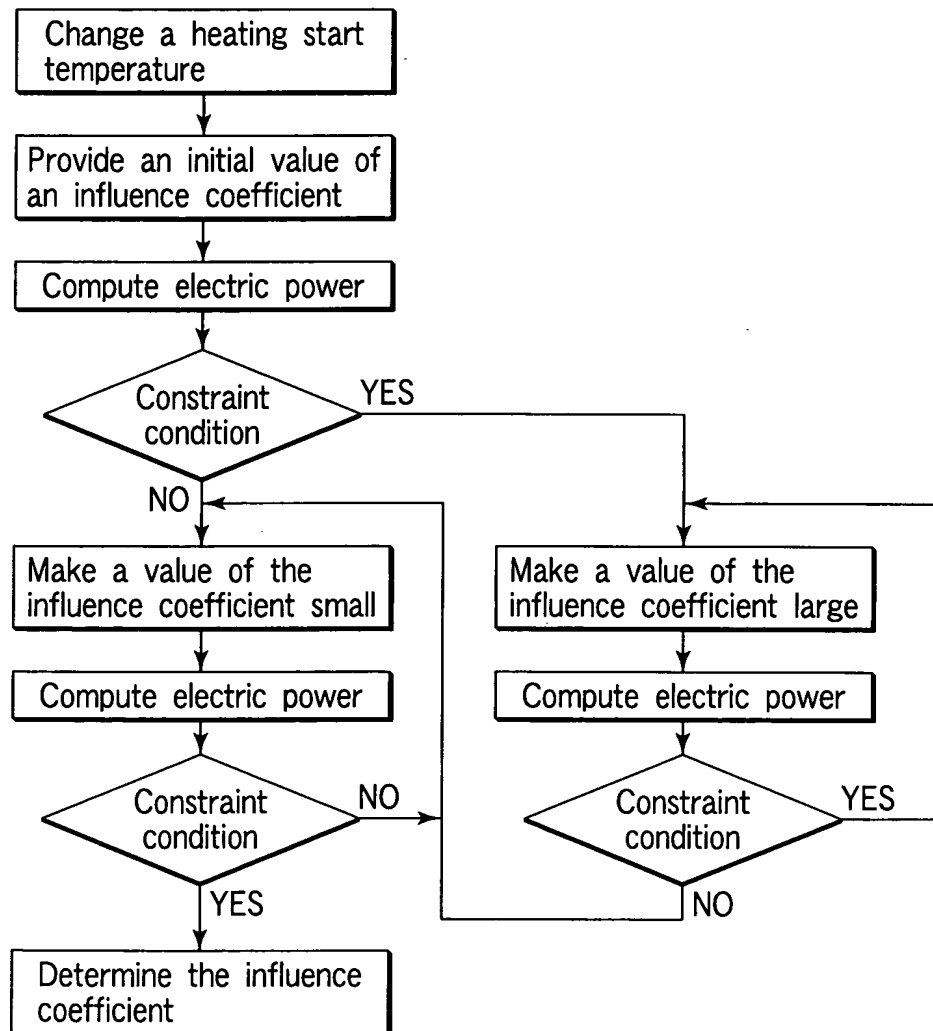


FIG. 10

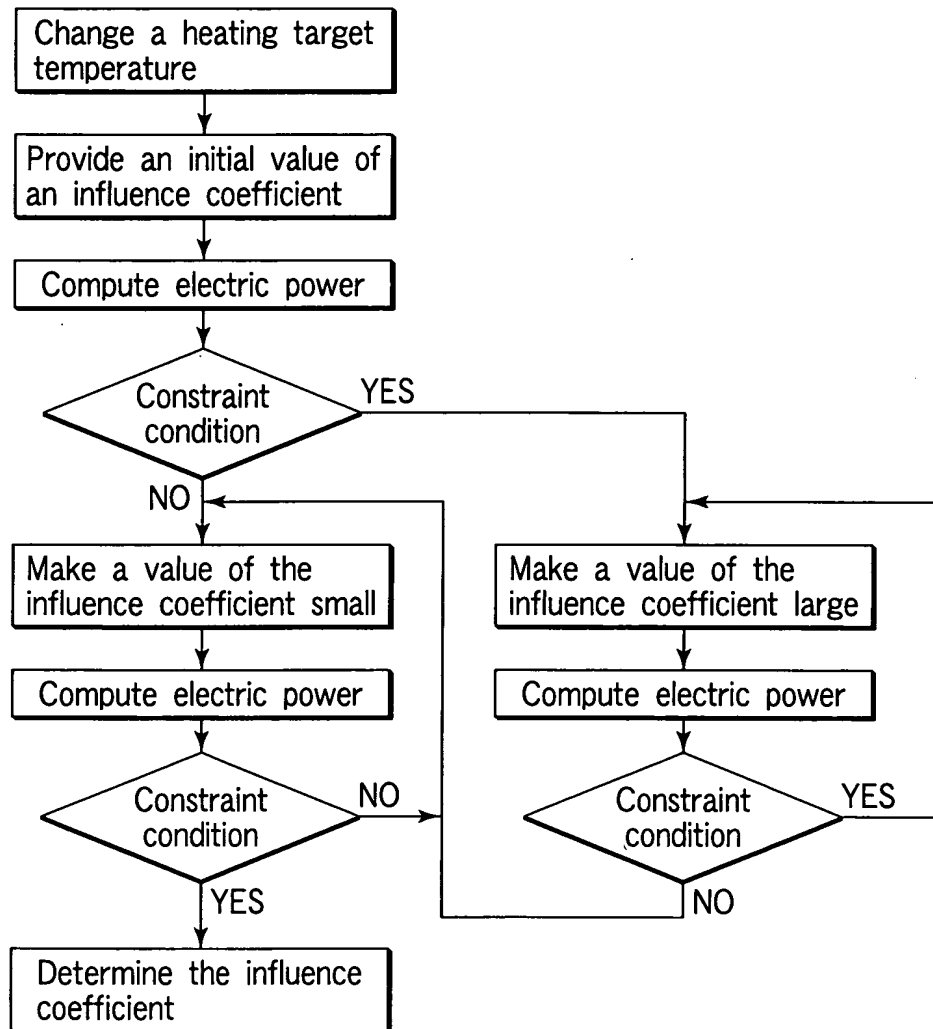


FIG. 11

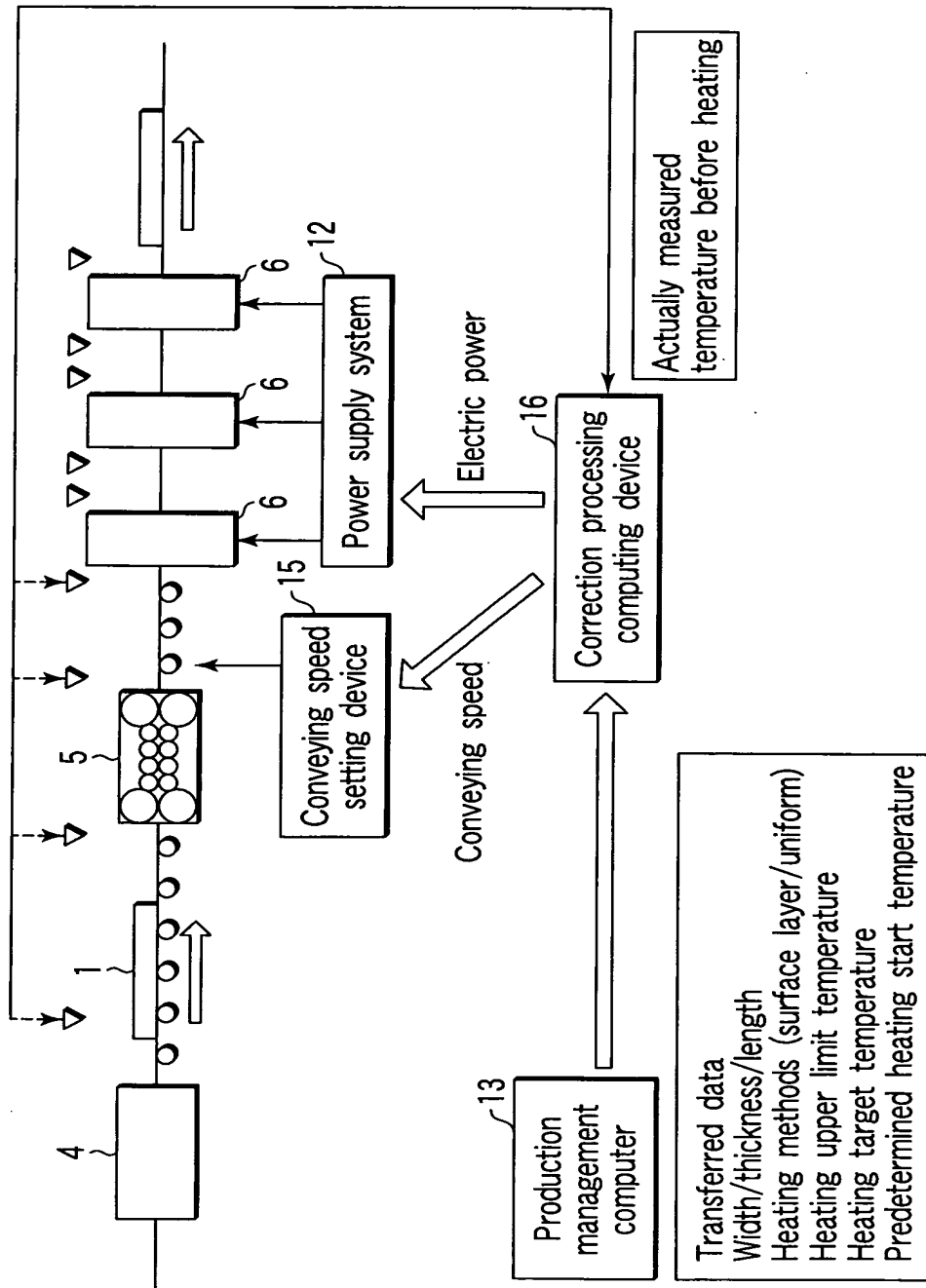


FIG.12

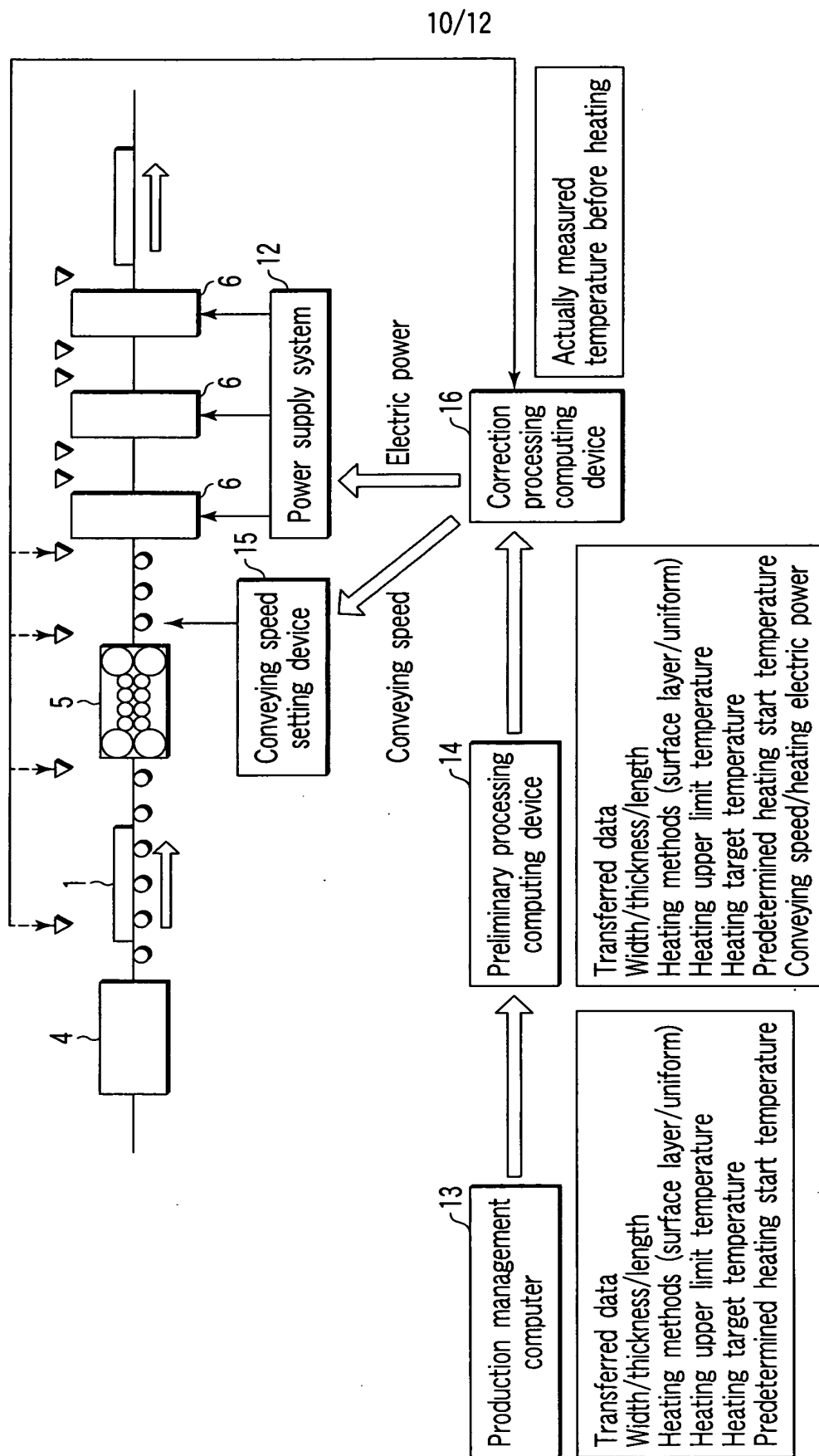


FIG. 13

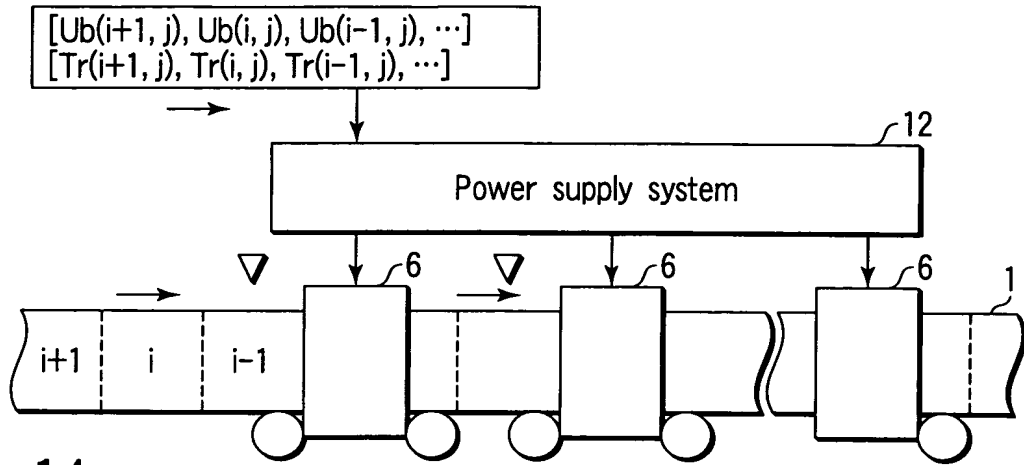


FIG. 14

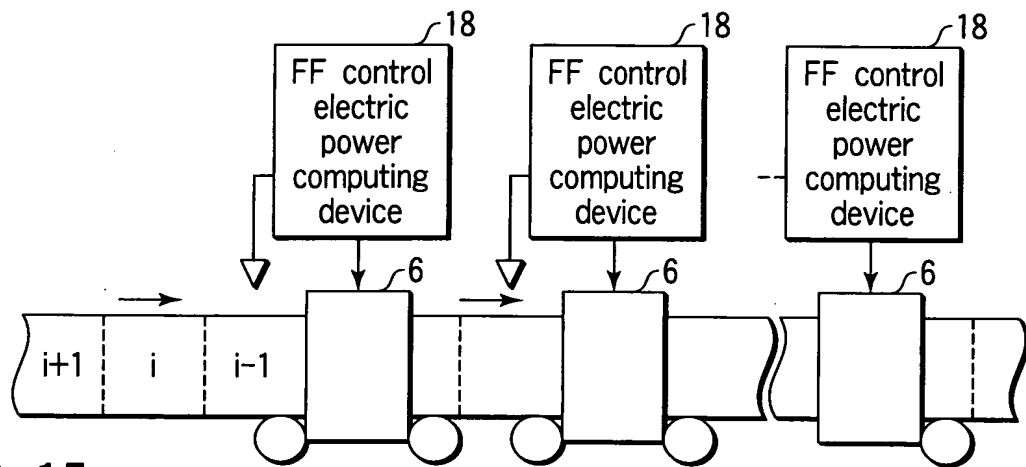


FIG. 15

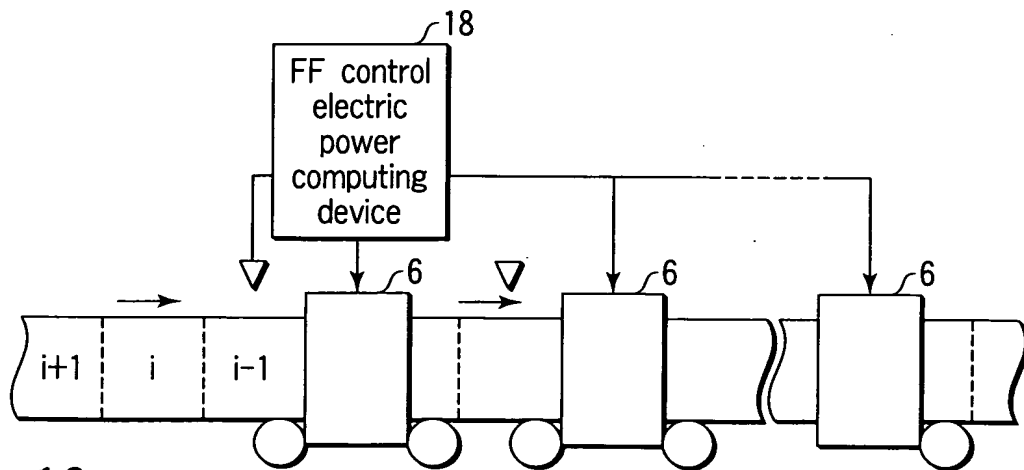


FIG. 16

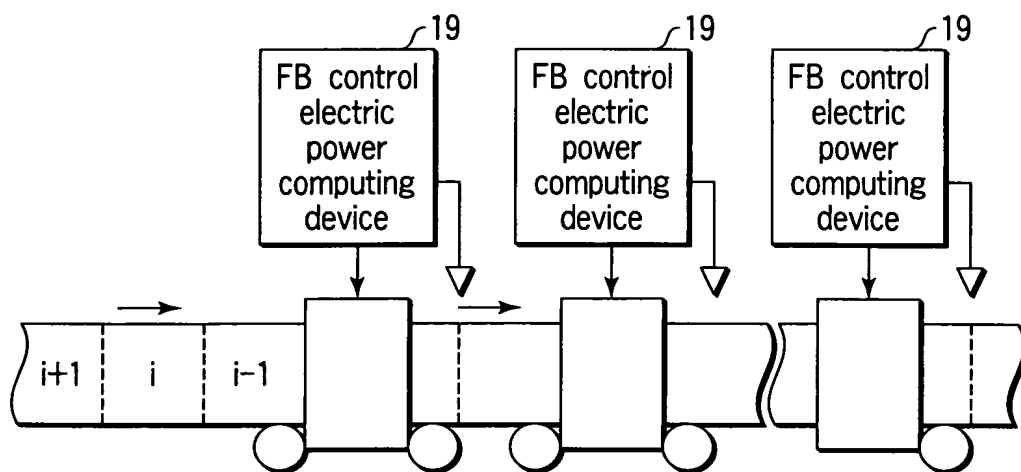


FIG. 17

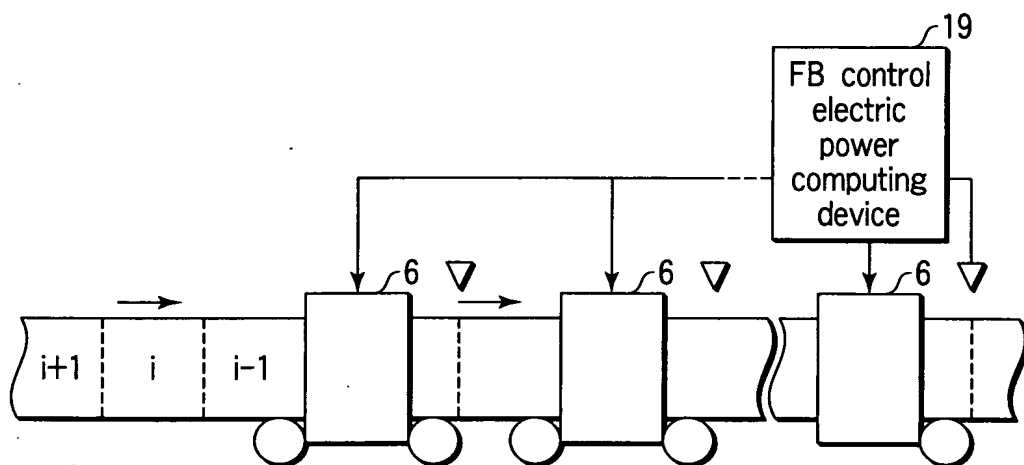


FIG. 18

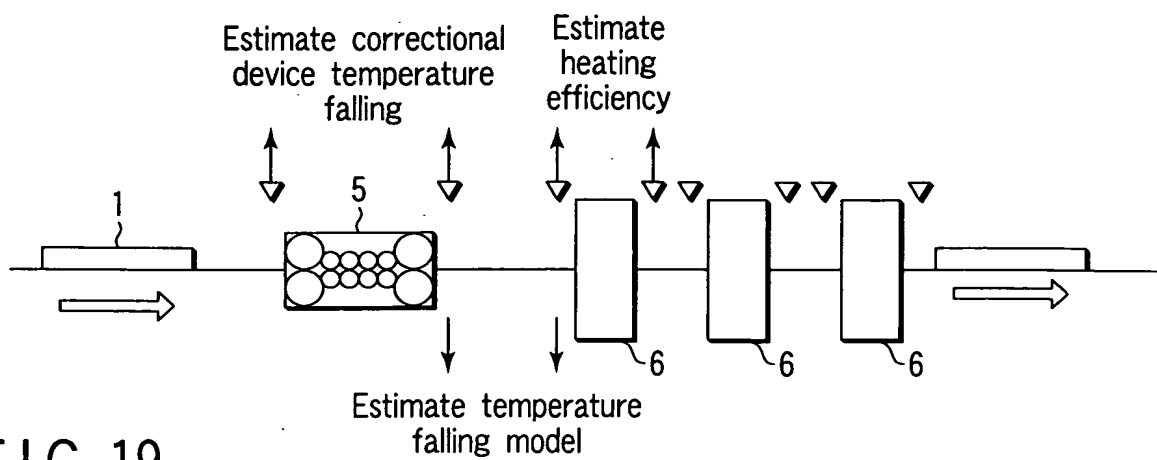


FIG. 19